

Work Order ID 69378

Tuesday, May 10, 2011 1:28:26 PM



Page 1

Item ID: D3890-3

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 5/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/11/2011 Req'd Qty: 4.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 11-05-10

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3890

A

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3890

Dwg Rev: *B*

Prog Rev: *A*

2-Deburr if necessary

11-5-11



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

11-5-11

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Accept



Setup Start



Revision ID:

Stop



Item Name: Gasket

Start Date: 5/10/2011 Start Qty: 4.00



Cust Item ID:

Required Date: 5/11/2011 Req'd Qty: 4.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

8 units



Quality Control

130

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

0.00

SB 11/05/11

8

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/5/13

mf

11-05-12

Quality Control

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Picklist Print

Tuesday, May 10, 2011 1:28:32 PM

Page 1

Work Order ID: 69378



Parent Item: D3890-3



Parent Item Name: Gasket



Start Date: 5/10/2011

Required Date: 5/11/2011

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP RevA: New issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M4111NS.125 		Purchased	No			100	sf	600.0000	0.026	0.109474			
													

4111 Black Neoprene/EPDM/SBR Blend Sheet 0.125"

Location

Loc Qty

Loc Code

MAT052

600

112335

100

114937

500

114937

(8)

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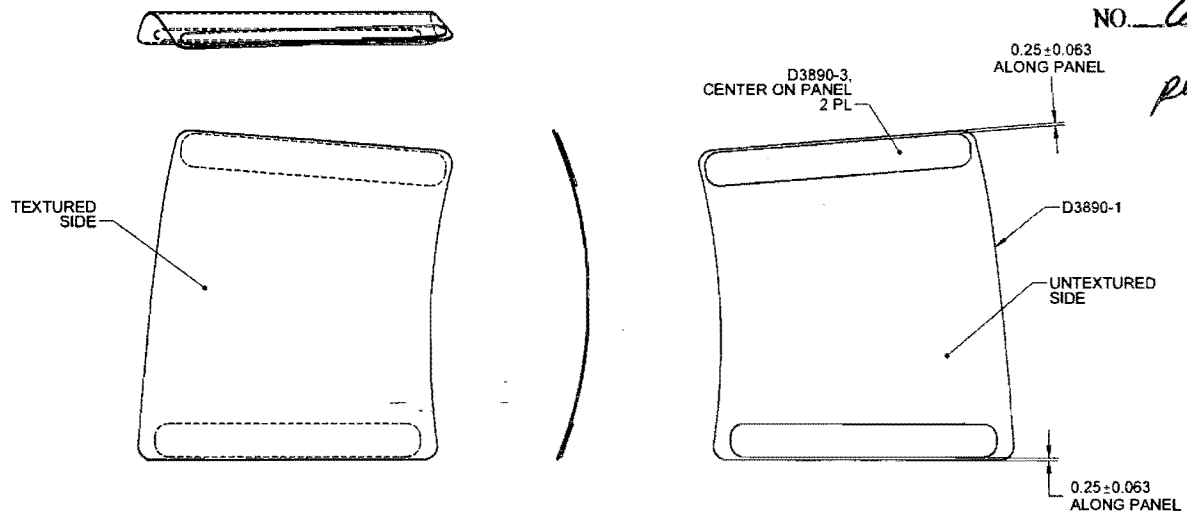
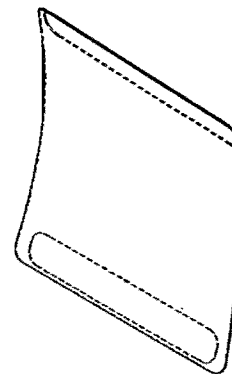
NOTE: Date & initial all entries

PARTS LIST

ITEM	QTY	P/N	DESCRIPTION
1	X	D3890-041	PANEL, SIDE
2	1	D3890-1	PANEL
3	2	D3890-3	GASKET
5	A/R	3M 1300	ADHESIVE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 69378

PL 11-05-10



D3890-041 PANEL, SIDE

RELEASED
01/26/10

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3890-041" AND B/N USING FINE POINT PERMANENT INK MARKER ON SMOOTH/UNTEXTURED SIDE OF PART
- 7) WEIGHT: 2.48 lbs
- 8) BOND GASKET TO SMOOTH/UNTEXTURED SIDE OF PART USING 3M 1300 ADHESIVE.

A	NEW ISSUE	CP	09.05.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>GP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>GP</i>		
CHECKED	<i>PH</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>PH</i>	D3890	SHEET 1 OF 4
APPROVED	<i>PH</i>	TITLE	SCALE
DE APPR.	<i>PH</i>	PANEL, SIDE	NTS
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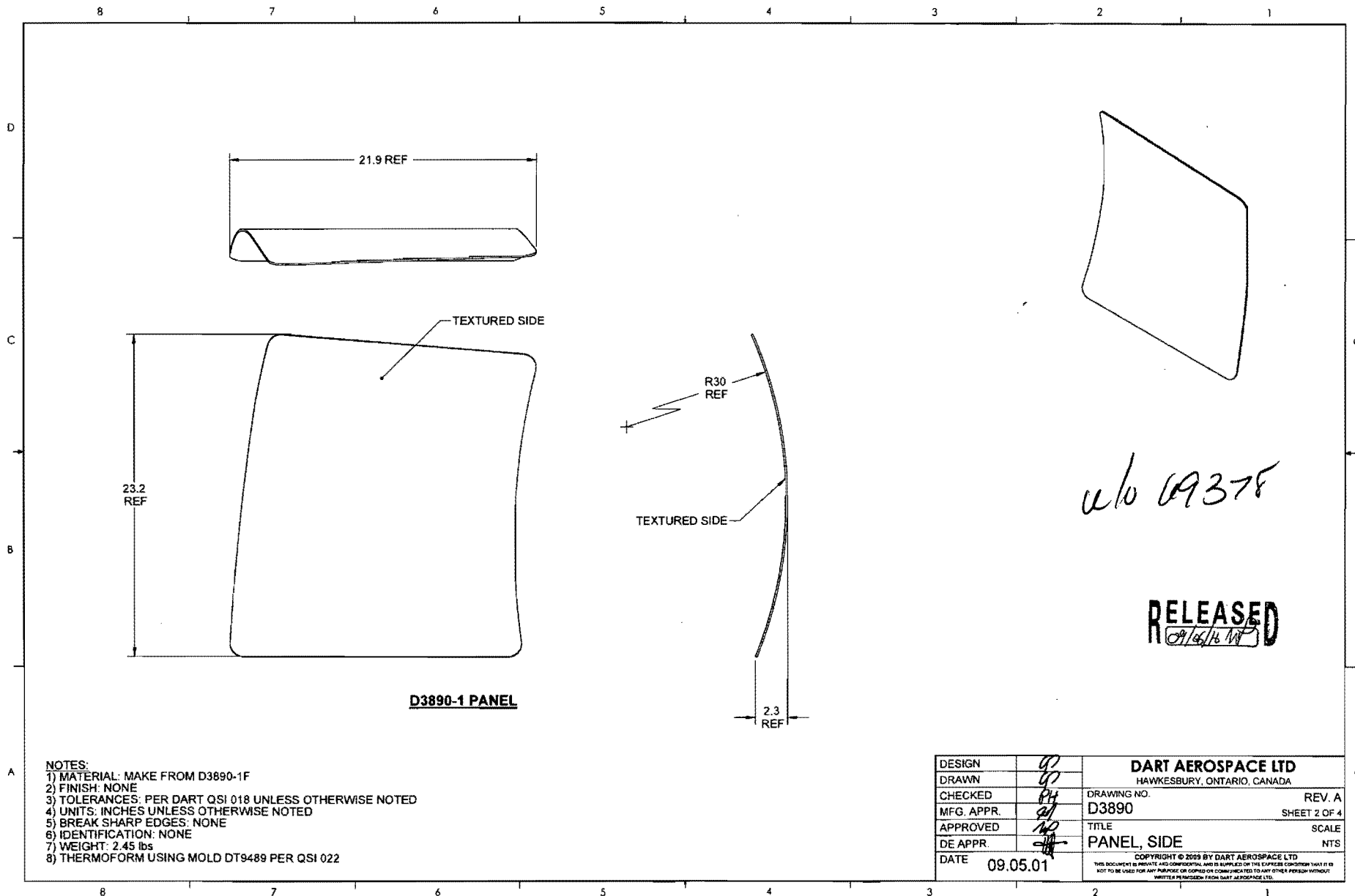
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DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
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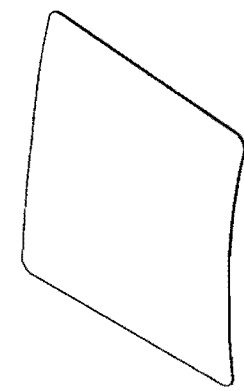
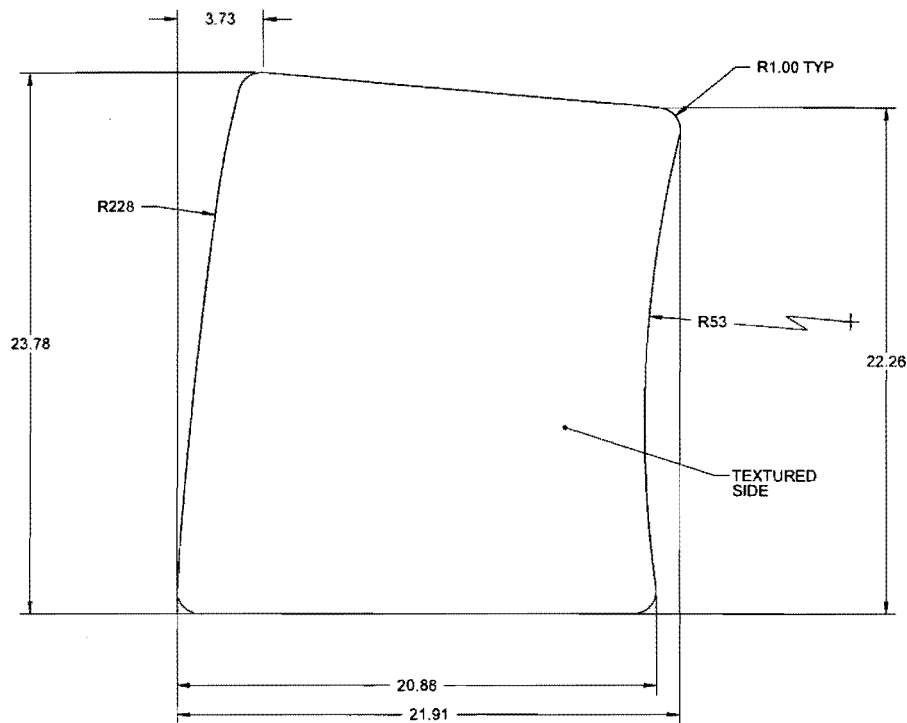
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NOTE: Date & initial all entries



10-69378

D3890-1F PANEL

RELEASED
9/66/16 MP

NOTES:

- 1) MATERIAL: F60029 GY3778 LEXAN SHEET (HEAVY HAIRCELL TEXTURE, DARK GREY), 0.125 THICK, TEXTURED SIDE UP (REF DART SPEC. MLEXS.125-F60029-04)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 2.45 lbs

DESIGN	<i>90</i>	DART AEROSPACE LTD	
DRAWN	<i>90</i>	HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	<i>94</i>	D3890	SHEET 3 OF 4
APPROVED	<i>99</i>	TITLE	SCALE
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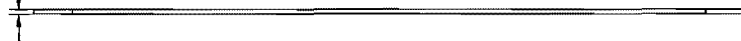
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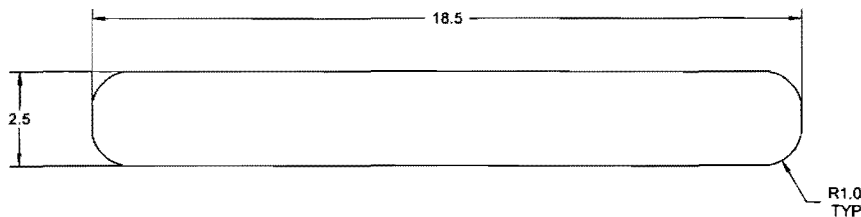
8 7 6 5 4 3 2 1

D

0.125
REF



C



D3890-3 GASKET

ab 69378

B

RELEASED
24/06/16 MTD

NOTES:

- 1) MATERIAL: NEOPRENE FOAM SHEET, 0.125 THICK
(REF DART SPEC. M4111N-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.02 lbs

A

DESIGN	GP	DART AEROSPACE LTD	
DRAWN	GP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PH	DRAWING NO.	REV. A
MFG. APPR.	PH	D3890	SHEET 4 OF 4
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8 7 6 5 4 3 2 1

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